

Wednesday, July 08, 2015 3:14:20 PM

134433

Page 1

Accept

N900040100

Setup Start *NS1*

Stop ***NS2***

Start Date: 7/07/15 **Start Qty:** 20.00 ***20***

Cust Item ID:

Required Date: 7/07/15 **Req'd Qty:** 20.00 ***20***

Customer:

Reference:

Approvals: Process Plan: MLJ Date: JUL 10 2015 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr	
D2873	Rev A	

100

BAND SAW

Bandsaw

Memo

Jeaspa Bandsaw

Cut blanks: 1.000" x 0.375" x 2.700" long

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

HAAS CNC vertical machine #1

Machine as per Folio FA and Dwg D2873 Identify as D2873-5
Dwg Rev A F1819 Folio Rev AA

120

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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				Lead hand / Supervisor Approval Verification																	
				QC / QA Coordinator Approval																	
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OTHER : _____																					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Work Order ID 134433

Wednesday, July 08, 2015 3:14:20 PM

134433

Page 3

Item ID: D2873-045 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Nut Plate Assembly
Start Date: 7/07/15 Start Qty: 20.00 ***20*** Cust Item ID:
Required Date: 7/07/15 Req'd Qty: 20.00 ***20*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Chemical Conversion Coat per QSI005 4.1	0.00							
160									
HandFinish	Memo	0.00							
Hand Finishing									
170	QC7-Inspect Chemical Conversion Coat	0.00							
170									
QC	Memo	0.00							
Quality Control									
180	Small Fab	0.00							
180									
Small Fab	Memo	0.01							
Small Fab	1-Assemble as per Dwg D2873 2-Identify as D2873-045								

20 0 15-7-30 DGL

20 0 15-7-30

20X 15/07/30

DAS
36
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : _____					

Wednesday, July 08, 2015 3:14:20 PM

134433

Page 4

Item ID:	D2873-045	Accept	*N900040100*	Setup	Start	*NS1*
Revision ID:						
Item Name:	Nut Plate Assembly				Stop	*NS2*
Start Date:	7/07/15	Start Qty: 20.00	*20*	Cust Item ID:		
Required Date:	7/07/15	Req'd Qty: 20.00	*20*	Customer:		
Reference:						

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run** **Start** ***NR1***
 QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** ***NR2***

[illegible]

SA 120150731

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

Wednesday, July 08, 2015 3:14:19 PM

Page 1

Work Order ID: 134433

134433

Parent Item: D2873-045

D2873-045

Parent Item Name: Nut Plate Assembly

Start Date: 7/07/15

Required Date: 7/07/15

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP A05.09.13New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.375X01.00 0		Purchased	No			180	f	44.0270	0.225	5			

M6061T6B0 375X01 000

6061T6 BAR .375 x 1.00

15/07/22

Location	Loc Qty	Loc Code
MAT001	44.027	
m132209	44.027	

MS20426AD4-6

Purchased

No

180

Each

2,314.000

4

80

MS20426AD4-6

Rivet

15/07/30

DAS
36
9-89

Location	Loc Qty	Loc Code
GA	166	
M128812	166	
MF4	177	
124392	177	
ST312	1971	
124392	83	
M128812	69	
M132536	1819	

MS21075L5

Purchased

No

100

Each

462.0000

2

40

MS21075L 5

Nut Plate

15/07/30

DAS
36
9-89

Location	Loc Qty	Loc Code
GA	154	
m132256	154	
ST300	308	
123346	8	
131317	300	

40

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Environment ☐	No Re-verification ☐																																																																			
Design ☐	Operator ☐																																																																			
Doc/Data ☐	Offset/Setup ☐																																																																			
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Material ☐	Use for Testing ☐																																																																			
Internal Transport ☐	Poor Information ☐																																																																			
Tribal Knowledge ☐	Rushing ☐																																																																			
LOA ☐	Product Improvement ☐																																																																			
Substation ☐	Process Improvement ☐																																																																			
Past Expiry Date ☐	Manufacturing Process ☐																																																																			
Misidentified ☐	Past Due ☐																																																																			
Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																																																																	
Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																																																																	
Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																																																																	
Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																																																																	
Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																																																																	
Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																																																																	
Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																																																																	
Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																																																																	
Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																																																																	
Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																																																																	
OTHER : _____																																																																				

DART AEROSPACE LTD		Work Order: 134433
Description: Radius Block		Part Number: D2873-5
Inspection Dwg: D2873 Rev: A		Page 1 of 1

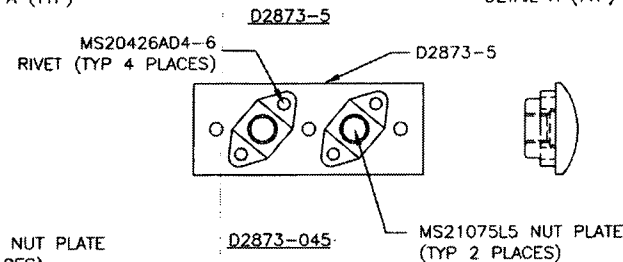
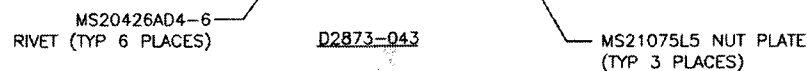
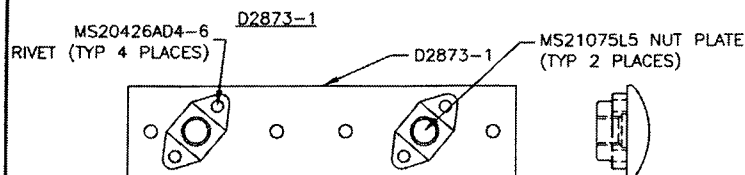
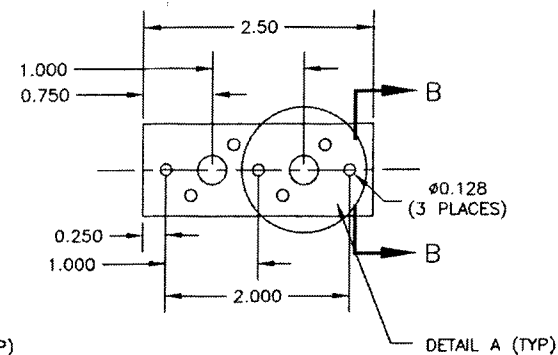
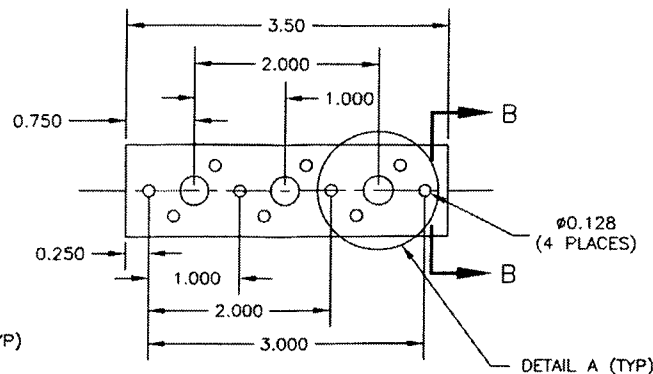
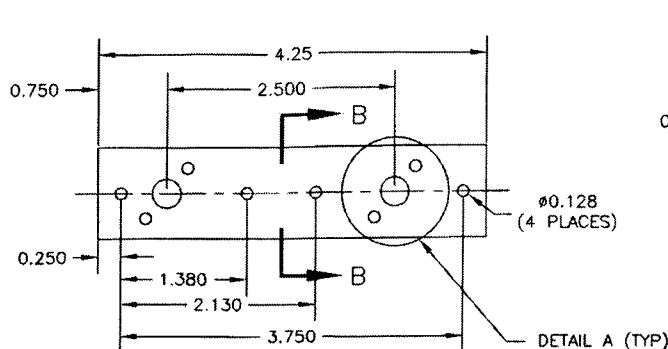
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.50	+/-0.030	2,502	✓		MIP-04	vern
1.000	+/-0.010	1,000	✓			
0.750	+/-0.010	0,748	✓			
0.250	+/-0.010	0,251	✓			
1.000	+/-0.010	1,000	✓			
2.000	+/-0.010	2,000	✓			
Ø0.128	+0.005/-0.001	0,130	✓			
0.359	+/-0.010	0,360	✓			
Ø0.316	+0.006/-0.001	0,317	✓			
1.000	+/-0.010	0,998	✓			
0.250	+/-0.010	0,250	✓			
0.061	+/-0.010	0,065	✓			
Ø0.230 x 0.125	+0.005/-0.001 x 0.010	0,229/0,130	✓		31006	Height gauge

Measured by: <i>[Signature]</i>	Audited by: JFC	Prototype Approval:	N/A
Date: 15/07/21	Date: 2015-07-23	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue P/O D2873-045	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>



D2873-1/-3/-5 RADIUS BLOCK

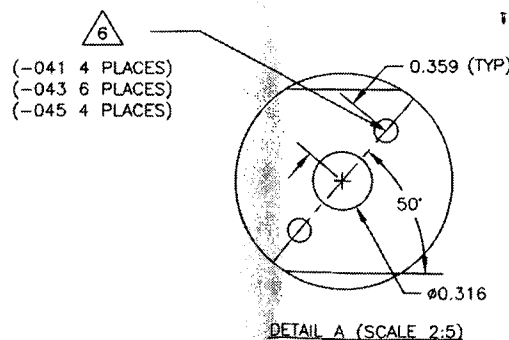
- 1) MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B1.000X0.250) OR 6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B1.000X0.250)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) Ø0.128 PILOT + C'BORE CURVED SIDE Ø0.230X0.125 DEEP + C'SINK CURVED SIDE Ø0.225 x 100°

D2873-041/-043/-045 NUT PLATE ASSEMBLY

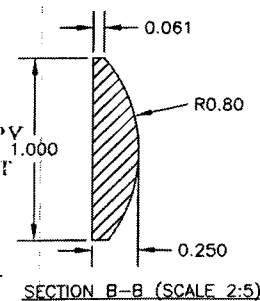
- 1) INSTALL MS21075L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-6 RIVETS

D2873-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST

-041	-043	-045	PART NUMBER	DESCRIPTION
X			D2873-041	NUT PLATE ASSEMBLY
	X		D2873-043	NUT PLATE ASSEMBLY
		X	D2873-045	NUT PLATE ASSEMBLY
1			D2873-1	RADIUS BLOCK
	1		D2873-3	RADIUS BLOCK
		1	D2873-5	RADIUS BLOCK
4	6	4	MS20426AD4-6	RIVET
2	3	2	MS21075L5	NUT PLATE



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UNCONTROLLED COPY
SUBJECT: ALIGNMENT
WITH PROPOSED
WORK ORDER
NO. 134433
ML5
1507-10



RELEASED
1507-10

A	05.07.26	NEW ISSUE
DESIGN PH	DRAWN BY PH	DART DART AEROSPACE LTD WARRICKBURG, ONTARIO, CANADA
CHECKED <u>PH</u>	APPROVED <u>PH</u>	DRAWING NO. D2873
DATE 05.07.26	TITLE RADIUS BLOCK	REV. A SHEET 1 OF 1 SCALE 4:5